User:

Friday, 04/05/2007 6:49:15 AM

Linda Lacelle

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 32100

Estimate Number : 11395 : N/A P.O. Number

This Issue

: 04/05/2007

S.O. No. : NA

Prsht Rev. First Issue

Previous Run

Written By

Checked & Approved By Comment

Type

: PURCHASED PARTS

New issue KJ/JLM

Drawing Name : CREW WINDOW

: D32771 Part Number **Drawing Number**

: D3277 REV A : N/A

Project Number Drawing Revision

Material **Due Date**

: 11/05/2007

Qty:

Each

4 Um:

Additional Product

Job Number:



A05.03.22

Seq. #:

Machine Or Operation:

Description:

1.0

MACRLICS125

1/8" Polycast II Sheet

FLOW WATER JET



Comment: Qty.:

5.4327 sf(s)/Unit Total: 21.7308 sf(s)

1/8" Polycast II Sheet

BATCH: M104596

07/06/24

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3277

Dwg Rev:_ Prog Rev:_

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



4.0 QC8

SECOND CHECK





Comment: SECOND CHECK

5.0

QC6

DIMENSIONAL CHECK





Comment: DIMENSIONAL CHECK



Date:

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Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CREW WINDOW

Job Number: 32100

Part Number: D32771

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

7.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



W A-2626



D 41101	tonday, 4/30/2007 7:22:20 AM im Johnston	Droces Shoo			 .
1		Process Shee			
Customer	: CU-DAR001 Dart Helicopters Servic	es Drawing I	Name : CREW WINDOV	V	
Job Number	: 32100				
Estimate Number	er : 11395	Down More	ber : D32771		
P.O. Number	: : 4/30/2007 S.O. No. :	Part Num Drawing P	===:		
This Issue	: 4/30/2007 S.O. No. : : NC	Project 1	•		
Prsht Rev. First Issue		ASED PARTS Drawing F			
Previous Run	: 25337	Material	:		
	. 14	Due Date	: 5/10/2007	Qty:	4 Um: Eac
Written By		30			
Checked & Appl Comment	: Est. A 05 03.22 Ne	w issue KJ/JLM			
Additional Prod	uct				
Job Number:					
Seq. #:	Machine Or Operation:	Description	1:		
1.0	PG	PURCHASING	<i>(</i> '		
Com	nment: PURCHASING	1 141 29	(\ /	P
: 42 1	Issue P/O:	/ On 1		\ \\	
	Manufacture D3277-1as per Dwg	D3277	_\	0.1 N () \	
	Possible Supplier: Canus	N/ P	$^{\prime}\bigvee$	$w \times w$	
	Material release note is required	1 7		, ()	
2.0	D32771P	Crew Window, R44			
				د ا	
Com		otal : 4.0000 Each(s)			•
	Crew Window, R44	7.5	05.111		
3.0	PACKAGING 1	PACKAGING RESOUR	JE #1	11	
	1 1881 <u>88</u> 1118 118 11 <u>88</u> 11 188 1				
Com	ment: PACKAGING RESOURCE #1				
	Recieive & Inspect for Transit Da				
	Ensure Material Release Note is				
4.0	QC6	DIMENSIONAL CHECK		25 1(BA) (B) (AA)	
	ment: DIMENSIONAL CHECK				
5.0	PACKAGING 1	PACKAGING RESOURC	CE #1	12 11 4 8 4 11 4 1 1 18 1	
			\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\		
Com	ment: PACKAGING RESOURCE #1	·			
	Identify and Stock				
	Location:		\		
				`	

Page 1

Dart Aeı	rospace	Ltd
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07 US	5.0	QC6 not necessary. Denne. Derm. Change				ina.25	10-ce 25
Part No):	PAR #: Pault Category: No	CR: Yes	No DQ	A:	Date:	

QA: N/C Closed: ____ Date: ____

NCR:		1	WORK ORDE	ER NON-CONFORMANO	E (NCR)			
DATE STE		Description of NC		Corrective Action Section B		Verification		
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Monday, 4/30/2007 7:22:20 AM Date: Kim Johnston "User: **Process Sheet** Drawing Name: CREW WINDOW Customer: CU-DAR001 Dart Helicopters Services Part Number: D32771 Job Number: 32100 Job Number: Description: Seq. #: Machine Or Operation: FINAL INSPECTION/W/O RELEASE QC21 6.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					,		
Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _	

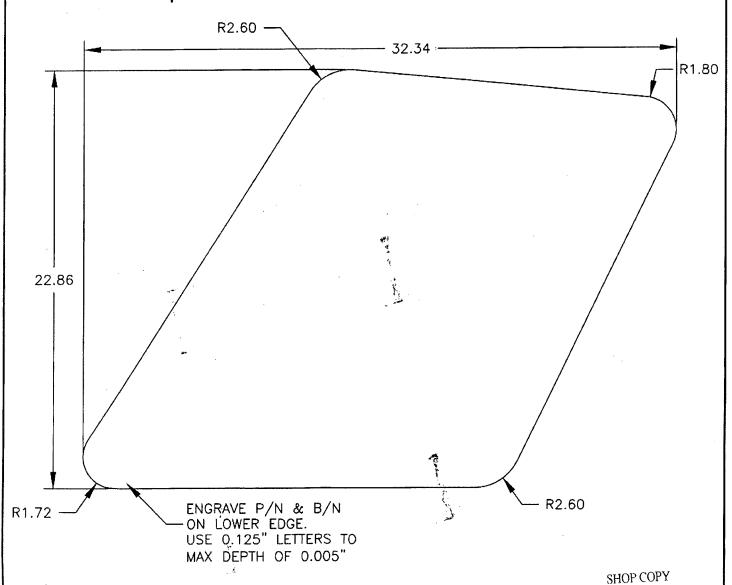
QA: N/C Closed: ____ Date: ____

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
\		Description of NC		Corrective Action Section B		Varification		A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
							55%	

NOTE: Date & initial all entries



DESIG	N UP	DRAWN BY	DART AEROSPAC HAWKESBURY, ONTARIO, C	
CHECK	(ED A)	APPROVED A	DRAWING NO.	REV. A
	Alt	- #-	D3277	SHEET 1 OF 1
DATE			TITLE	SCALE
04.0	8.23		CREW WINDOW (R44)	1:5
Α		04.08.23	NEW ISSUE	



D3277-1 WINDOW

RETURN TO 1) CUT PER TEMPLATE D3277-1T1 2) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425, 0.125 THICK ENGINEERING

UNCONTROLLED COPY (REF DART SPEC. M-ACRYLIC-S.125) SUBJECT TO AMENDMENT

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WITHOUT NOTICE

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DART AEROSPACE LTD .	Work Order:	32100
Description: CREW Window	Part Number:	D32 77 1
Inspection Dwg: D3277 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

•	х	First Artic	<u></u>	Proto		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.34	160.030	32.36	_		M-T	
22.86	+1-0.030	22.87	1		M-T Vem	
0.125	+1.0.010	0.120			Vem	
						·
	_			·		
					·	

Measured by:	SAN	Audited by:	En	Prototype Approval:	W		
Date:	07/06/24	Date:	0766/25	Date:	/	4	

Rev	Date	Change	Revised by	Approved
А			KJ/JLM	